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Date: Monday, 7/9/2007 11:50:50 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	"T" HANDLE ASSEMBLY		
Job Number	33390A					
Estimate Number	11179					
P.O. Number	N/A		Part Number	D2282041		
This Issue	7/9/2007	S.O. No.	N/A	Drawing Number	D2282 REV E	
Prsht Rev.	NC		Project Number	N/A		
First Issue	N/A		Drawing Revision	E		
Previous Run	33256A		Material	N/A		
Written By			Due Date	7/30/2007 Qty: 100 Um: Each		
Checked & Approved By						
Comment	Est Rev:A	Removed from 9 Digit	05-12-02	JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D22823	Tube	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2282-3 Handle tube <u>B33259</u>			
<u>Mo7/08/02</u> (S1)			
2.0	D22825	Tube	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2282-5 Handle tube <u>B33260</u>			
<u>Mo7/08/02</u> (S1)			
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
Comment: LARGE FABRICATION RESOURCE 1  1-Weld as per D2282-041 'T' Handle Assembly Grind chamfers and ensure full penetration.  A/R ER316L SS Filling Rod <u>M18712</u> Dwg Rev: <u>E</u>			
<u>PD 07-08-07</u> (S1)			
4.0	DO NOT USE <u>QC 9</u>	WELD INSPECTION	
Comment: WELD INSPECTION			
<u>Mo7/08/07</u> (S1)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 108108 Date: 11/08/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: "T" HANDLE ASSEMBLY
Job Number: 33390A		Part Number: D2282041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: SMALL & MEDIUM FAB RESOURCE 1		
Tumble <span style="float: right;">SA 07.08.08 (51)</span>		
6.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP <span style="float: right;">EP 07/08/08 (51)</span>		
7.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>      </u> <span style="float: right;"><i>Jr 1/8/08 (51)</i></span>		
8.0	QC21	FINAL INSPECTION/W/O RELEASE
		
Comment: FINAL INSPECTION/W/O RELEASE <span style="float: right;">1 27/08/08</span>		
Job Completion		 <span style="float: right;">C 27/08/08</span>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

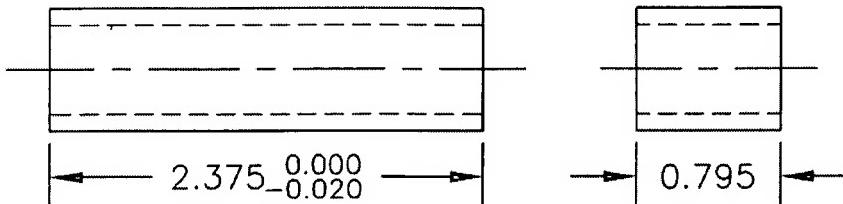
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



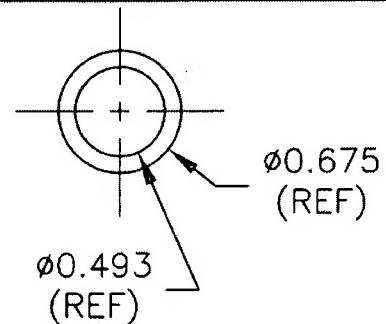
DESIGN BW	DRAWN BY <i>PB</i>	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>IP</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	



D2282-3

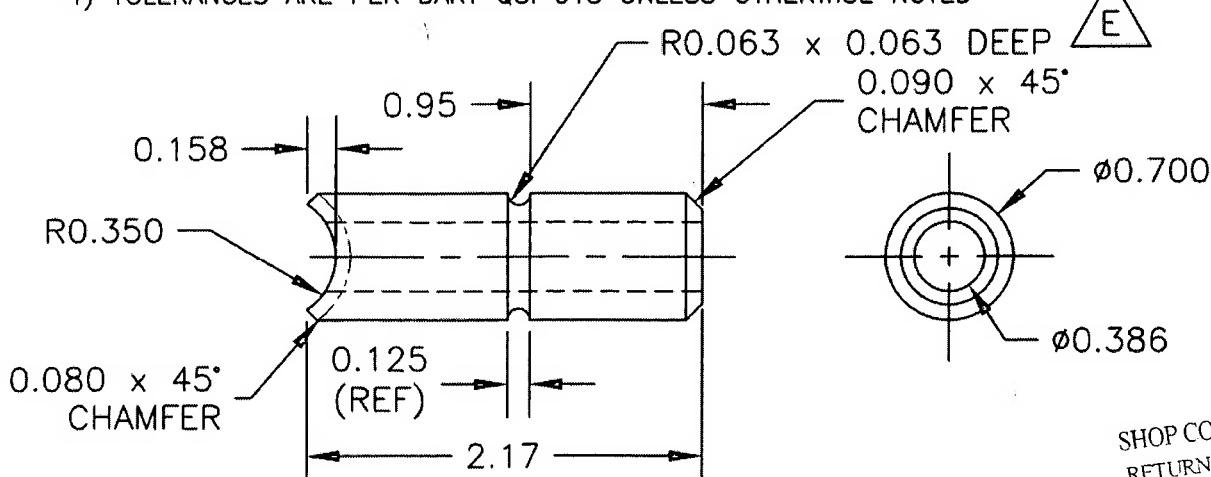


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

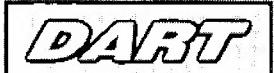


D2282-5

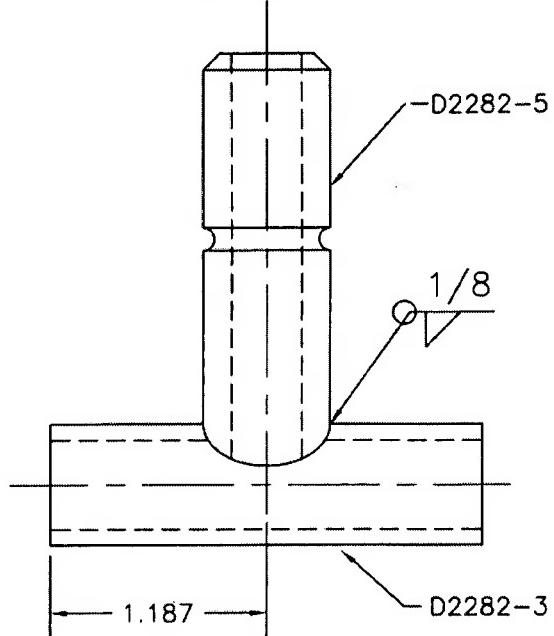
D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

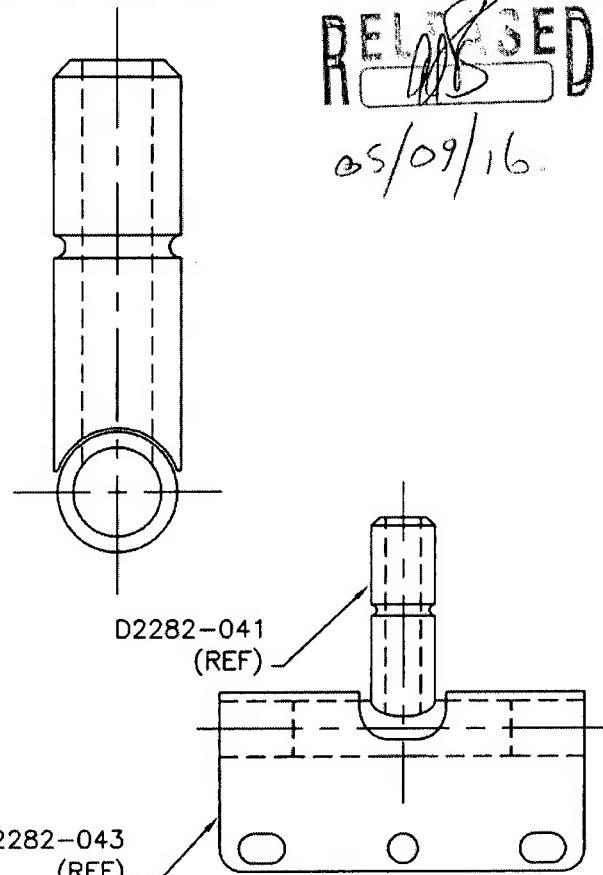
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E WORK ORDER  
NO 33390A



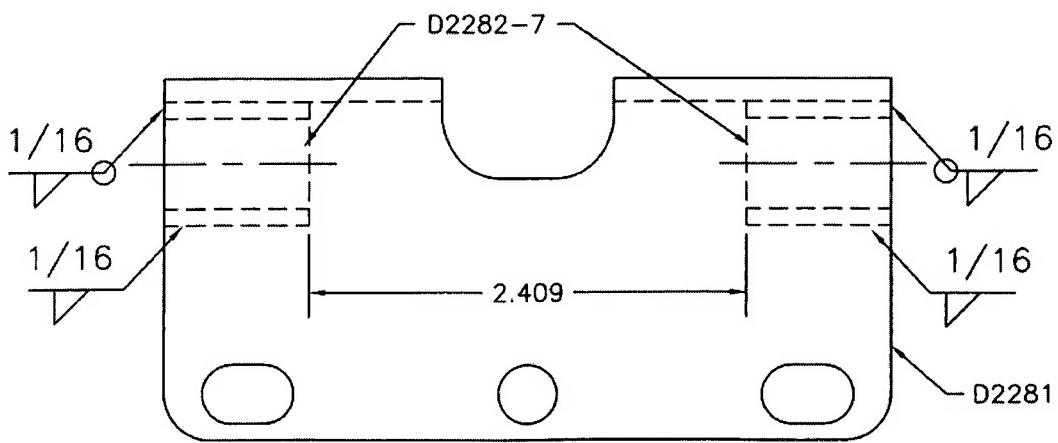
DESIGN BW	DRAWN BY <i>RP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY  
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY  
SCALE 1:2



D2282-043 SADDLE ASSEMBLY  
WELD ASSEMBLY PER DART QSI 004

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